SIG SAUER®

*when it counts™*

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SIG SAUER®

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# P238

## OWNERS MANUAL: HANDLING & SAFETY INSTRUCTIONS

**READ THE INSTRUCTIONSAND WARNINGS IN THIS MANUAL CAREFULLY BEFORE USING THIS FIREARM; DO NOT DISCARD THIS MANUAL.**

This instruction manual should always accompany this firearm and be transferred with it upon ownership, or when the firearm is loaned or presented to another person.

## ⚠ WARNING - LOCKING DEVICES

This firearm was originally sold with a key-operated locking device. While it can help provide secure storage for your unloaded firearm, any locking device can fail. All guns are designed to fire if they are loaded and the trigger is pulled. Therefore, never install the locking device inside the trigger guard or in any way that makes it possible to pull the trigger! Do not leave the keys in the lock.

The ultimate responsibility for secure storage of any firearm must depend upon its owner and his or her individual circumstances. Firearms should be stored unloaded, in a secure location, separate from their ammunition.

**NEVER INSTALL THE LOCKING DEVICE INSIDE THE TRIGGER GUARD**

To maximize effectiveness and reduce the chances of malfunction or damage to a firearm, ALWAYS refer to the locking device's manufacturer directions for installation and removal of the device.





## FIREARMS SAFETY IS YOUR RESPONSIBILITY

This owner's manual is designed to assist you in learning how to use and care for your SIG SAUER® pistol properly.

Only when you are certain that you fully understand this manual and can properly carry out its instructions, should you practice loading and firing your firearm with live ammunition. Having a gun in your possession is a full-time job; you cannot guess and you cannot forget. You must know how to use your firearm safely.

If you have any doubts about your ability to handle or use this firearm safely, you should seek supervised instruction. The Sig Sauer Academy™ provides all levels of firearms safety and skill training, from beginner to expert.

For more information contact:

SIG SAUER ACADEMY

www.sigsaueracademy.com • (603) 679-2003

| | |
|---|---|
| Main campus: | Epping, New Hampshire |
| Satellite Facilities: | Range 82, Midland, VA |
| | NRA Whittington Center, Raton, NM |

**SAFETY MUST BE THE FIRST AND CONSTANT CONSIDERATION OF EVERY PERSON WHO HANDLES FIREARMS AND AMMUNITION.**

For more information about safety, responsible firearms ownership, and shooting sports, contact:

National Rifle Association (NRA) of America

11250 Waples Mill Road, Fairfax, VA 22030-7400 • 1-800-672-3888

www.nra.com

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## WARNINGS OF GREAT IMPORTANCE ARE FOUND WITHIN THIS MANUAL

SELECT FOR FULL WARNING


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**OTHER CAUTIONS AND WARNINGS APPEAR THROUGHOUT THE MANUAL**

## FIREARMS ARE DANGEROUS WEAPONS

## READ THE INSTRUCTIONS AND WARNINGS IN THIS MANUAL THOROUGHLY AND CAREFULLY BEFORE USING.

### ⚠ WARNING - ALTERATIONS

This product was designed to function properly in its original condition. Alterations can make it unsafe. Do not alter any part or add or substitute any parts or accessories not manufactured by SIG SAUER Inc.

**DO NOT ALTER ANY GUN**





## 1.0 Safety Rules

The safety warnings in this manual are important. By understanding the dangers inherent in the use of any firearm, and by taking the precautions described herein, you can experience complete safety in the use of your pistol. Failure to heed any of these warnings may result in serious injury to you or others, as well as severe damage to the firearm or other property.

PISTOLS are classified as FIREARMS and are sold by SIG SAUER with the specific understanding that we shall not be responsible in any manner whatsoever for malfunctioning of the firearm, physical injury or property damage resulting in whole or in part from:

- criminal or negligent discharge;
- improper or careless handling;
- unauthorized modifications; defective, improper, hand-loaded,
- or reloaded ammunition;
- corrosion;
- neglect; or
- other influences beyond our direct and immediate control.

This limitation applies regardless of whether liability is asserted on the basis of contract, negligence, or strict liability (including any failure to warn). Under no circumstance shall SIG SAUER, Inc. be liable for incidental or consequential damages, such as loss of use of property, commercial loss, and loss of earnings or profits.

## 1.1 Protect Your Eyes and Ears

Always wear safety glasses that meet the requirements of American National Standards Institute (ANSI) Z87.1 and ear plugs or “earmuff” type protectors whenever you are shooting. Always make certain that persons close to you are similarly protected. Unprotected eyes may be injured by powder, gas, carbon residue, lubricant, metallic particles, or similar debris that may emanate occasionally from any firearm in normal use. Without ear protection, repeated exposure to shooting noise may lead to cumulative, permanent hearing loss.

# 2.0 Mechanical Characteristics and Weapon Theory

## 2.1 Weapon Description

### 2.1.1. General

The SIG SAUER pistol is a modern handgun incorporating the latest technical advances in weapon design for military, law enforcement and sporting use. They are mechanically locked, short recoil operated pistols with semi-automatic reloading. Firing takes place with each pull of the trigger until the magazine is empty. The slide remains open after the last round has been fired from the magazine.

### 2.1.2 Principal Features

The single action only trigger, in combination with the thumb safety, ensures safe carrying of the weapon and provides instant readiness when needed.

The automatic firing pin safety blocks the firing pin unless the trigger is pulled.

The hammer safety intercept notch prevents the hammer from contacting the firing pin unless the trigger is pulled.

The disconnector prevents the hammer from falling when the slide is out of battery (not fully closed).

The pistol can only be disassembled from the "slide open" position.

Distinctive high contrast sights and excellent ergonomics, ensure rapid target acquisition and engagement, even under poor lighting conditions.

Extremely compact dimensions and lightweight materials, combined with the powerful .380ACP cartridge, provide an excellent platform for concealed carry or personal protection.

The closed design of the pistol prevents dirt and other debris from entering the pistol, ensuring proper function in harsh environmental conditions.





### 2.1.3 What You Should Know About the Single Action Only Trigger System

The P238 is a Single Action Only (SAO) pistol. This pistol incorporates many of the same safety features found in other SIG Sauer pistols, including the firing pin safety, hammer safety intercept notch, and disconnector. The P238 features an integrated thumb safety, located above and to the rear of the left-hand grip.

The thumb safety blocks hammer movement and can be engaged with the hammer cocked (ready to fire) or hammer forward.

Move the thumb safety fully upward to engage. The thumb safety is ON (SAFE) when fully up.

Move the thumb safety fully down to disengage. The thumb safety is OFF (FIRE) when fully down. When the thumb safety is down, the hammer is free to fall when the trigger is pulled

You can cycle the slide when the thumb safety is engaged with the hammer cocked. When the thumb safety is engaged with the hammer forward, slide movement is blocked.

## ⚠ WARNING – SAFETY

- With the pistol loaded, the thumb safety must be ON (UP) until ready to fire. Failure to engage the thumb safety can lead to accidental discharge, causing injury, death or damage to property.
- After each discharge, the pistol is in the cocked and ready to fire condition. When shooting is complete, you must engage the thumb safety or unload the pistol.
- Never disengage the thumb safety when pulling the trigger – the firearm will discharge when the thumb safety is moved into the OFF (FIRE) position when the trigger is depressed.
- Never lower the hammer by pulling the trigger and attempting to ease the hammer forward manually. Manually lowering the hammer is dangerous and prevents full application of the pistol's safety features. Accidental discharge could result, causing injury, death or damage to property.





## 2.2 Main Parts

| | | | | | |
|---|---|---|---|---|---|
| 1 | - | Frame | 10 | - | Trigger |
| 2 | - | Slide stop | 22 | - | Front sight |
| 3 | - | Thumb safety | 23 | - | Rear sight |
| 4 | - | Barrel | 27 | - | Grip plate |
| 5 | - | Slide | 28 | - | Grip screw |
| 6 | - | Hammer | 40 | - | Magazine |
| 8 | - | Magazine catch | | | |

*Note: Refer to section 13 for a detailed parts list and diagram.*

## 3.0 Ammunition

1. Use only high-quality, original, factory-manufactured ammunition. Do not use cartridges that are dirty, wet, corroded, bent, or damaged. Do not oil cartridges. Do not spray aerosol-type lubricants, preservatives, or cleaners directly onto cartridges or where excess spray may flow into contact with cartridges. Lubricant or other foreign matter on cartridges can cause potentially dangerous ammunition malfunctions. Only use ammunition of the caliber for which your firearm is chambered. The proper caliber is permanently engraved on your firearm; never attempt to use ammunition of any other caliber.

2. The use of reloaded, "remanufactured" hand-loaded, or other non-standard ammunition voids all warranties. Reloading is a science and improperly loaded ammunition can be extremely dangerous. Severe damage to the firearm and serious injury to the shooter or to others may result. Always use ammunition that complies with the industry performance standards established by the Sporting Arms and Ammunition Manufacturers' Institute, Inc. (SAAMI) of the United States or ammunition manufactured to military specifications.

### ⚠ WARNING – AMMUNITION (CARTRIDGE) NOTICE

SIG SAUER SPECIFICALLY DISCLAIMS RESPONSIBILITY FOR ANY DAMAGE OR INJURY WHATSOEVER OCCURRING IN CONNECTION WITH, OR AS A RESULT OF, THE USE IN ANY SIG SAUER FIREARM OF FAULTY, NON-STANDARD, "REMANUFACTURED" HAND-LOADED (RELOADED) AMMUNITION, OR CARTRIDGES OTHER THAN THOSE FOR WHICH THE FIREARM WAS ORIGINALLY CHAMBERED.





3. Firearms may be severely damaged and serious injury to the shooter or to others may result from any condition causing excessive pressure inside the chamber or barrel during firing. Excessive pressure can be caused by obstructions in the barrel, propellant powder overloads, the use of incorrect cartridges, or defectively assembled cartridges. In addition, the use of a dirty, corroded, or damaged cartridge can lead to a burst cartridge case and consequent damage to the firearm and personal injury from the sudden escape of high-pressure propellant gas within the firearm's mechanism.

4. Immediately stop shooting and check the barrel for a possible obstruction whenever:
- You have difficulty in, or feel unusual resistance in, chambering a cartridge
- A cartridge misfires (does not go off)
- The mechanism fails to extract a fired cartridge case
- Unburned grains of propellant powder are discovered spilled in the mechanism
- A shot sounds weak or abnormal. In such cases it is possible that a bullet is lodged partway down the barrel. Firing a subsequent bullet into the obstructed barrel can wreck the firearm and cause serious injury to the shooter or to bystanders

5. Bullets can become lodged in the barrel:
- If the cartridge has been improperly loaded without propellant powder, or if the powder fails to ignite (ignition of the cartridge primer alone will push the bullet out of the cartridge case, but usually does not generate sufficient energy to expel the bullet completely from the barrel).
- If the bullet is not properly seated in the cartridge case. When such a cartridge is extracted from the chamber without being fired, the bullet may be left behind in the bore at the point where the rifling begins. Subsequent chambering of another cartridge may push the first bullet further into the bore.

6. If there is any reason to suspect that a bullet is obstructing the barrel, immediately unload the firearm and look through the bore. It is not sufficient to merely look in the chamber. A bullet may be lodged some distance down the barrel where it cannot easily be seen.

## ⚠ WARNING – LODGED BULLET

IF A BULLET IS IN THE BORE, DO NOT ATTEMPT TO SHOOT IT OUT BY USING ANOTHER CARTRIDGE OR BY BLOWING IT OUT WITH A BLANK OR ONE FROM WHICH THE BULLET HAS BEEN REMOVED. SUCH TECHNIQUES CAN GENERATE EXCESSIVE PRESSURE, DAMAGE THE FIREARM, AND CAUSE SERIOUS PERSONAL INJURY.

If the bullet can be removed with a cleaning rod, clean any unburned powder grains from the bore, chamber, and mechanism before resuming shooting. If the bullet cannot be dislodged by tapping it with a cleaning rod, send the firearm to SIG SAUER.

7. Dirt, corrosion, or other foreign matter on a cartridge can impede complete chambering and may cause the cartridge case to burst upon firing. The same is true of cartridges that are damaged or deformed.

8. Do not oil cartridges, and be sure to wipe the chamber clean of any oil or preservative before commencing to shoot. Oil interferes with the friction between cartridge case and chamber wall that is necessary for safe functioning, and subjects the firearm to stress similar to that imposed by excessive pressure.

9. Use lubricants sparingly on the moving parts of your firearm. Avoid excessive spraying of any aerosol gun care product, especially where it may get on ammunition. All lubricants and aerosol spray lubricants, in particular, can penetrate cartridge primers and cause misfires. Some highly penetrative lubricants can also migrate inside cartridge cases and cause deterioration of the propellant powder; on firing, the powder may not ignite. If only the primer ignites, there is danger that the bullet may become lodged in the barrel.





## ⚠ WARNING - AMMUNITION

Death, serious injury, and damage can result from the use of wrong ammunition, bore obstructions, powder overloads, or incorrect cartridge components. Always wear shooting glasses and hearing protectors.

**IMPROPER AMMUNITION DESTROYS GUNS**

## ⚠ WARNING - LEAD EXPOSURE

Discharging firearms in poorly ventilated areas, cleaning firearms, or handling ammunition may result in exposure to lead and other substances known to the state of California to cause birth defects, reproductive harm, and other serious physical injury. Maintain adequate ventilation at all times. Wash hands thoroughly after exposure.

**SHOOTING OR CLEANING GUNS MAY EXPOSE YOU TO LEAD**

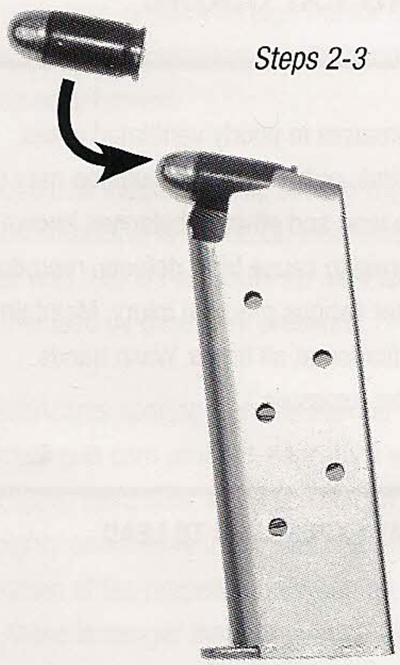
# 4.0 Handling

## 4.1 Preparation Instructions

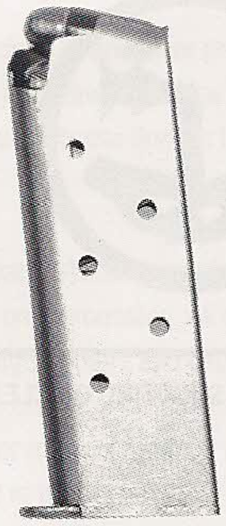
If you have the pistol and ammunition, and have read and understood all of the safety instructions, you are now ready to use the pistol.

## 4.2 Loading the Magazine

1. Ensure the magazine is the proper type and caliber for the pistol.
2. Press down on the magazine follower with the cartridge case rim. Ensure the bullet is facing the front of the magazine.
3. Push the cartridge to the rear and under the magazine lips.
4. Repeat until the magazine holds the desired number of cartridges.



*Steps 2-3*



*Step 4*





## 4.3 Loading the pistol (ready to fire)

1. Point the pistol in a safe direction.
2. Insert a full magazine and ensure it is engaged.
3. Pull the slide back fully and release, allowing the slide to fly forward.
4. Place thumb safety ON (safety UP).

**⚠ WARNING – LOADED PISTOL**

THE PISTOL IS NOW LOADED AND READY TO FIRE.

## 4.4 Reloading During Shooting

When the last round in the magazine is expended, the slide will be locked back in the open position by the slide stop.

1. Place the thumb safety ON (safety UP).
2. Depress the magazine catch.
3. Remove the empty magazine.

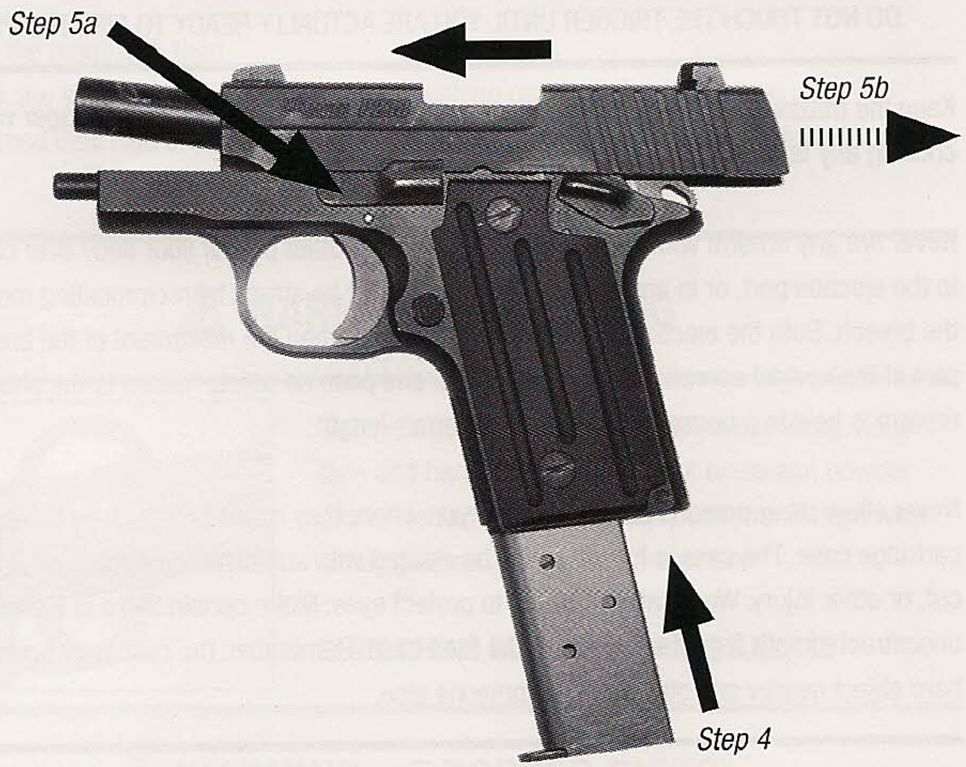
4. Insert a loaded magazine, making sure it is engaged.
5. Release the slide by:
   a. Pressing down on the slide stop or,
   b. Pulling back on the slide and release
   *(see illustration on page 23)*





## ⚠ WARNING – LOADED PISTOL

THE PISTOL IS NOW LOADED AND READY TO FIRE.




Always make sure the muzzle is pointed in a safe direction! Never attempt to load or unload any firearm inside a vehicle,building, or other confined space (except a properly constructed shooting range). Enclosed areas frequently offer no completely safe direction to point the firearm; if an accidental discharge occurs, there is great risk of bodily injury or property damage. Before loading, always clean all grease and oil from the bore and chamber, and check to be certain that no obstruction is in the barrel. Any foreign matter in the barrel could result in a bulged or burst barrel or other damage to the firearm, and could cause serious injury to the shooter or to others.

## 5.0 Firing

### ⚠ WARNING – TRIGGER

DO NOT TOUCH THE TRIGGER UNTIL YOU ARE ACTUALLY READY TO FIRE THE PISTOL.

Keep the muzzle pointed in a safe direction and your finger away from the trigger when cocking any firearm.

Never fire any firearm with your finger, hand, face, or other part of your body over or adjacent to the ejection port, or in any position where you may be struck by reciprocating movement of the breech. Both the ejection of empty cartridge cases and the movement of the breech are part of the normal operating cycle of firearms, and pose no safety hazard to the shooter if the firearm is held in a normal grip and fired at arm's length.

Never allow other persons to stand beside you where they might be struck by an ejected cartridge case. The case is hot, and may be ejected with sufficient force to cause a burn, cut, or other injury. Wear safety glasses to protect eyes. Make certain there is a clear, unobstructed path for safe ejection of the fired case. Remember, the case may bounce off a hard object nearby and strike you or someone else.

### ⚠ WARNING – MALFUNCTION

IF, WHILE SHOOTING, YOUR FIREARM DEVELOPS A MECHANICAL MALFUNCTION OR BINDING, OR "SPITS" POWDER/GAS, OR IF A CARTRIDGE PRIMER IS PUNCTURED, OR A CARTRIDGE CASE IS BULGED OR RUPTURED, OR IF THE REPORT ON FIRING DOES NOT SOUND QUITE RIGHT, STOP SHOOTING IMMEDIATELY! IT MAY BE DANGEROUS TO CONTINUE. UNLOAD THE FIREARM – DO NOT TRY "ONE MORE SHOT." TAKE THE FIREARM AND THE AMMUNITION TO A GUNSMITH FOR EXAMINATION.





## 5.1 Clearing a Jam

While shooting any firearm, an unfired cartridge or fired cartridge case may occasionally become jammed between the slide and the barrel. WHILE KEEPING THE MUZZLE POINTED IN A SAFE DIRECTION, clear the jam as follows:

1. Remove the magazine, then
2. Pull back the slide and lock it to the rear by pushing up the slide catch lever.
3. The jammed cartridge or case now can be removed by shaking it out or by picking it out.

### ⚠ WARNING – HANDLING

The slide opens and shuts quickly while firing. Keep face and hands away from it. Hot brass and powder gas is ejected quickly and can burn you. Always wear safety glasses and hearing protectors.

**SLIDE OPENS FAST – HOT BRASS EJECTED**

### ⚠ WARNING – DROPPED PISTOL

If dropped, the pistol may fire. Keep the chamber empty unless actually firing!

**ANY GUN MAY FIRE IF DROPPED**

## 5.2 Firing the Pistol

Aim the pistol at a safe target

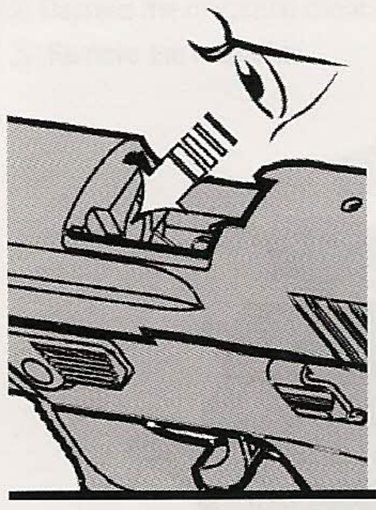
1. Place thumb safety OFF (safety DOWN).
2. Place finger on the trigger and pull back to discharge.
3. Keep pistol aimed at the target and continue to fire as required or until the pistol is empty.

4. Remove the magazine, unload and clear the pistol (see section 6.0 “Unloading the Pistol”). If the pistol is fired until the magazine is empty, the slide will remain locked to the rear. If firing is to continue, reload the pistol (see section 4.4 “Reloading During Shooting”).





## ⚠ WARNING – UNLOADING



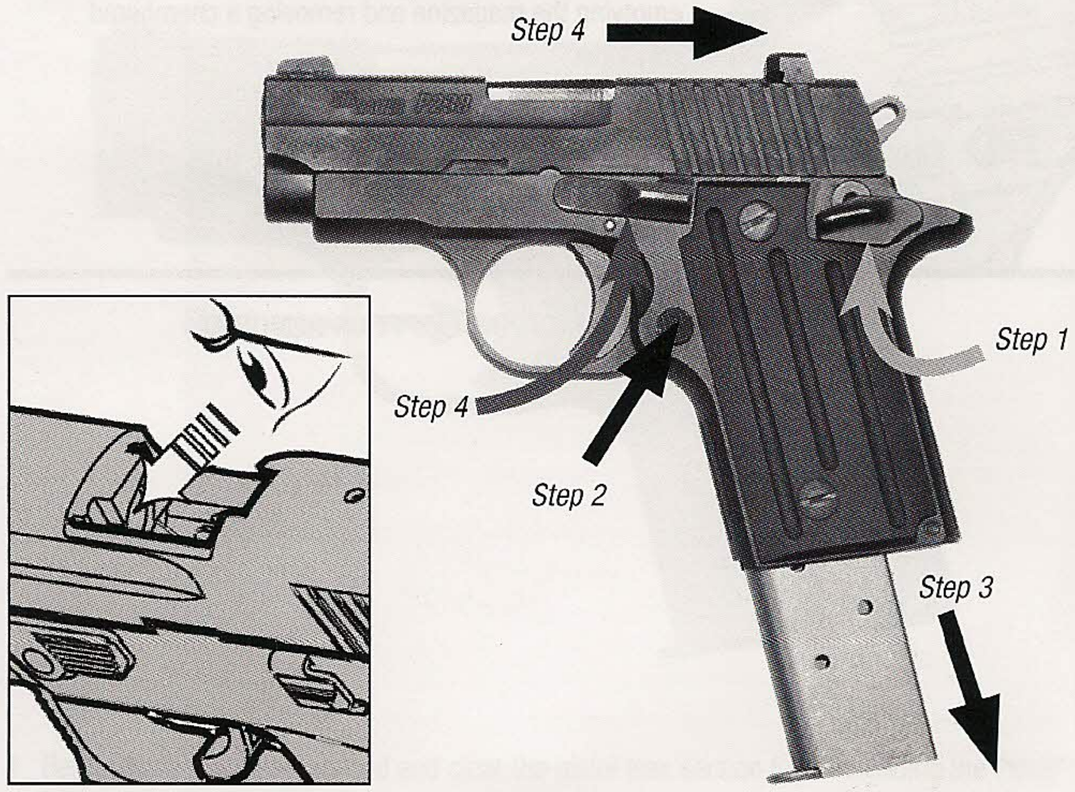
Removing cartridges from the magazine does not prevent the pistol from being fired! When there is a cartridge in the chamber, the cartridge will discharge if the trigger is pulled. It is absolutely essential for the user to know how to completely unload the pistol. “Completely” means emptying the magazine and removing a chambered cartridge.

**PISTOL WILL FIRE WITH MAGAZINE EMPTY OR REMOVED**

# 6.0 Unloading the Pistol

## 6.1 Unloading the Pistol (Magazine not Empty)

- Keep the muzzle pointed in a safe direction.
1. Place thumb safety ON (safety UP).
2. Depress the magazine catch.
3. Remove the magazine.
4. Pull the slide back to the rear and lock open with the slide stop.



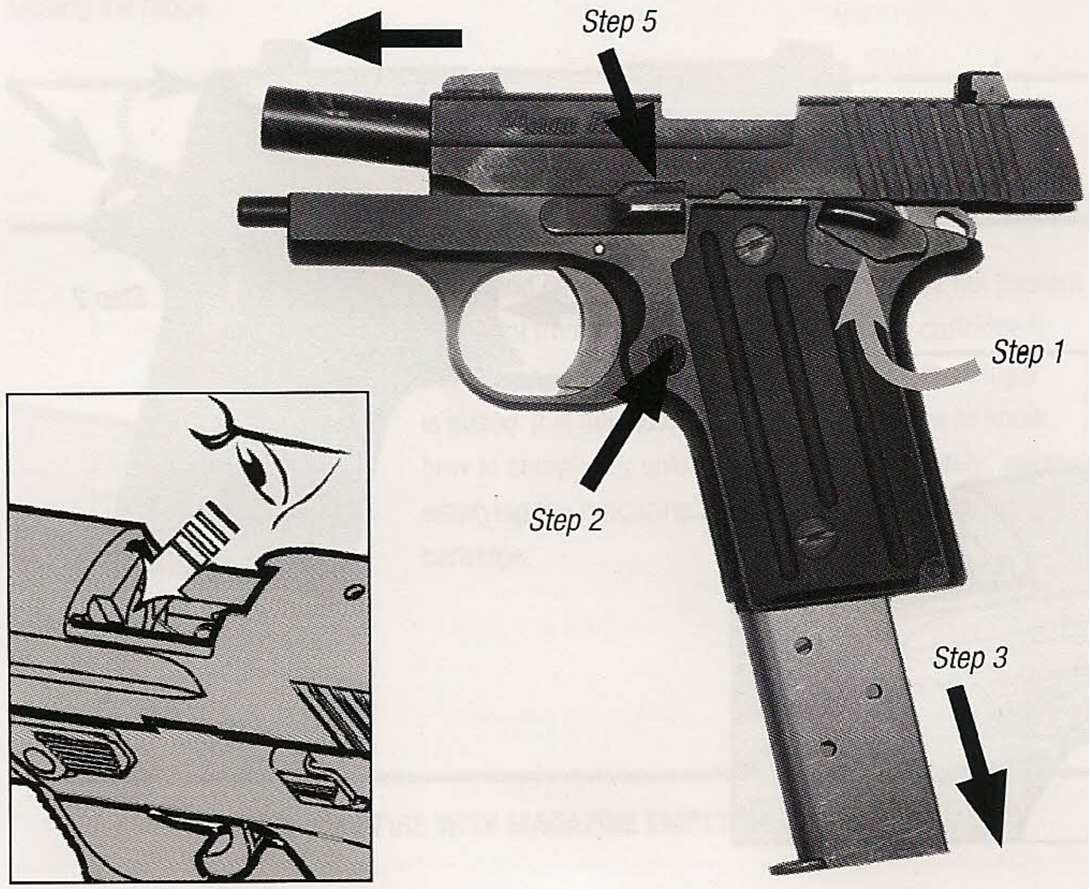

5. Visually and manually check the chamber to ensure the pistol is completely free of ammunition.
6. Depress the slide stop, causing the slide to close.





## 6.2 Unloading the Pistol (Magazine Empty, Slide Open)

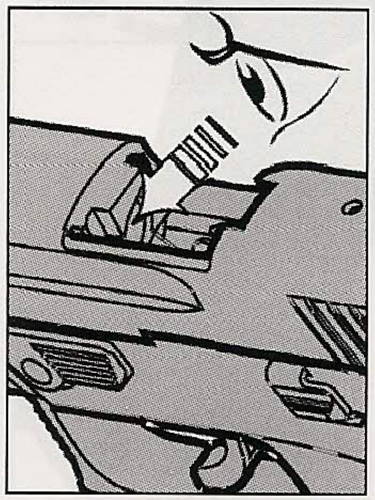
- Keep the muzzle pointed in a safe direction.
1. Place thumb safety ON (safety UP).
2. Depress the magazine catch.
3. Remove the magazine.




4. Visually and manually check the chamber to ensure the pistol is completely free of ammunition.
5. Depress the slide stop, causing the slide to close.

## 6.3 Lowering the Hammer (storage)

1. Follow instructions contained in sections 6.1 ("Unloading the Pistol, Magazine not Empty") or 6.2 ("Unloading the Pistol, Magazine Empty, Slide Open").
- Perform the following steps ONLY after verifying (visually and manually) the pistol is completely free of ammunition –



2. Place thumb safety OFF (safety DOWN).
3. Depress the trigger, allowing hammer to fall.





Always make sure the muzzle is pointed in a safe direction! Remember to clear the chamber after the magazine has been removed.

Never assume that any gun is unloaded until you have personally checked it, visually and physically!

After every shooting practice, make a final check to be certain the firearm is unloaded before leaving the range.

### ⚠ WARNING – UNLOADING

Removing cartridges from the magazine does not prevent the pistol from being fired! When there is a cartridge in the chamber, the cartridge will discharge if the trigger is pulled. It is absolutely essential for the user to know how to completely unload the pistol. "Completely" means emptying the magazine and removing a chambered cartridge.

**PISTOL WILL FIRE WITH MAGAZINE EMPTY OR REMOVED**

## 7.0 Procedures in Case of Malfunction ("Jam")

Follow the malfunction mitigation procedures if:

- You notice that a cartridge is difficult to chamber
- A cartridge does not go off
- The mechanism fails to extract a fired cartridge case
- You discover unburned grains of propellant powder spilled in the mechanism
- A shot sounds or feels weak or abnormal

### ⚠ WARNING – JAM

LIVE ROUND JAM MAY NOT EJECT.

Firearms work reliably if properly maintained. If there is a malfunction during firing:

1. Keep the pistol pointed in a safe direction with your finger off the trigger.
2. Remove and secure the magazine.
3. Move the slide rearward and forward to clear any cartridge case in or near the chamber. Visually and manually inspect the chamber.
4. If you suspect that a bullet is lodged in the bore, field strip your pistol and check to see if the barrel is blocked. If there is a bullet lodged in the bore, return the pistol to SIG SAUER (see section 11.3 "Shipping Firearms for Repair").

### ⚠ WARNING – JAM

IF A BULLET IS IN THE BORE, DO NOT ATTEMPT TO SHOOT IT OUT BY USING ANOTHER CARTRIDGE, OR BY BLOWING IT OUT WITH A BLANK OR A CARTRIDGE FROM WHICH THE BULLET HAS BEEN REMOVED. THIS CAN GENERATE EXCESSIVE PRESSURE, DAMAGE THE FIREARM AND CAUSE SERIOUS PERSONAL INJURY OR DEATH.



SIG SAUER®

Limited Lifetime

Firearms Warranty

FIRST-CLASS
POSTAGE
REQUIRED.
Post Office will
not deliver without
proper postage.

SIG SAUER
Attn: Warranty Processing
18 Industrial Drive
Exeter, NH 03833





## 7.1 Troubleshooting Guide

| Malfunction | Cause | Correction |
|---|---|---|
| **Feed** | | |
| No round fed into the chamber | Magazine not properly inserted or magazine is deformed or dirty | Insert magazine properly or change magazine |
| Slide does not close easily or completely | Pistol or cartridge is fouled (dirty) or pistol is too heavily lubricated | Clean and lubricate pistol and/or replace the ammunition |
| | Incorrect ammunition | Replace ammunition |
| | Pistol requires service | Return to SIG SAUER |
| **Extraction/Ejection** | | |
| After firing, the case stays in the chamber or is jammed in the ejection port | Insufficient recoil due to dirt | Clean and lubricate the pistol |
| | Light hold or limp wrist | Solid grip, rigid hold |
| | Low-powered ammunition | Change ammunition |
| | Pistol requires service | Return to SIG SAUER |
| **Ignition** | | |
| Hammer drops but round does not fire | Firing pin obstructed | Inspect, clean and lubricate the pistol |
| | Faulty ammunition | Manually cycle in next round |
| | Pistol requires service | Return to SIG SAUER |

## ⚠ WARNING – JAMS

If your pistol stops firing with a live round in the chamber of a hot barrel (a misfire or jam), remove the round immediately. If you cannot remove the round within 10 seconds, remove the magazine and wait at least 15 minutes with the pistol pointing in a safe direction. This way, neither the user nor any other person would be injured by the possibility of a round "cooking-off" (a round detonating due to the heat of the barrel). Keep your face away from the ejection port while clearing a hot chamber.

## 7.2 Minimizing Malfunctions ("Jams")

Malfunctions can largely be avoided by cleaning the pistol (see section 8.3 "Cleaning the Pistol").

- After each firing session
- Whenever a buildup of firing residue is suspected
- Whenever the pistol is exposed to extreme environmental conditions (rain, snow, freezing temperatures, etc.)





# 8.0 Maintenance

## ⚠ WARNING – MAINTENANCE

Verify the magazine is removed – visually and physically confirm the pistol is unloaded before attempting disassembly or performing any maintenance steps. Failure to ensure the firearm is unloaded could result in unintentional discharge, causing injury or death.

**VERIFY THE FIREARM IS UNLOADED**

## 8.1 Pistol Disassembly

1. Unload the pistol (see section 6.0 “Unloading the Pistol”).
2. Manually retract the slide until the slide disassembly notch is aligned with the slide stop tab.
3. Remove the slide stop from the frame.

**⚠ WARNING**

Slide is under spring tension. Maintain positive control during slide removal to prevent damage or injury. Wear eye protection.





4. Move the slide assembly forward until removed from the frame.

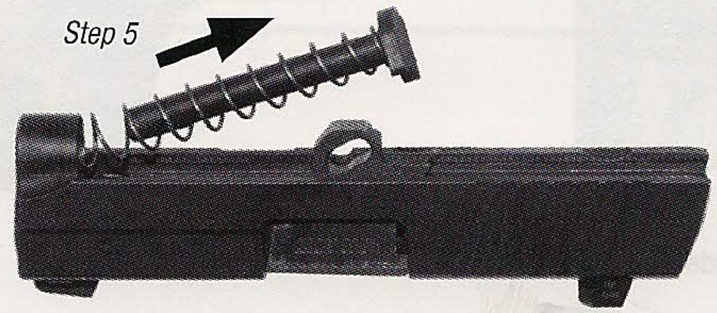
**⚠ WARNING**

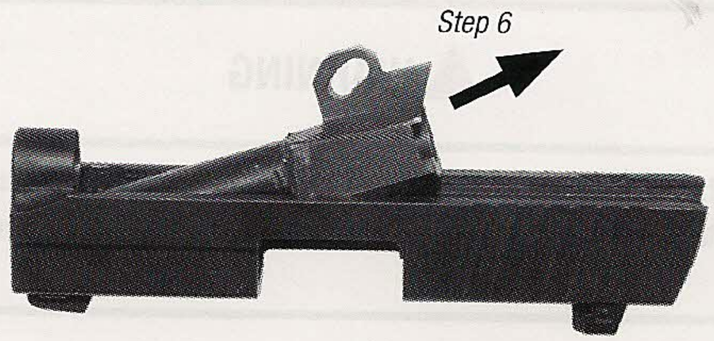
Do not engage the thumb safety with the slide removed. Moving the thumb safey to the up (ON) position with the slide removed will cause the safety detent plunger to separate from the frame.

## ⚠ WARNING

The recoil spring and guide are under spring tension and not firmly attached to the slide. Use caution to prevent injury or damage to the pistol. Wear eye protection.

5. Push the recoil spring guide forward slightly and lift from rear to remove the recoil spring and guide from the slide.
6. Remove the barrel from the slide by pulling upward slightly and to the rear.



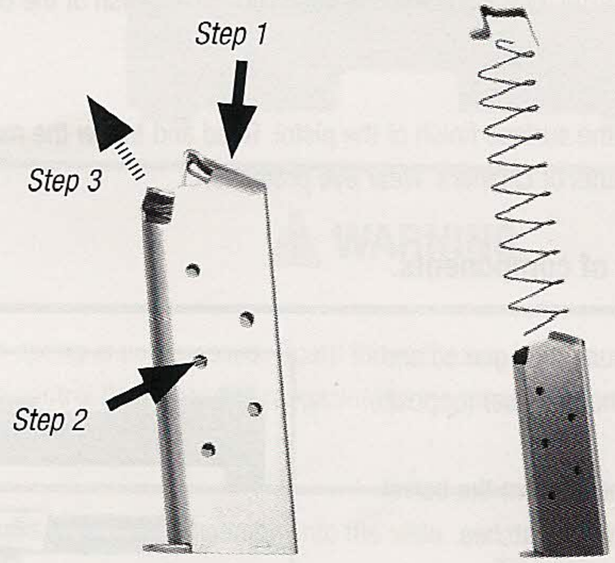

- This level of disassembly is sufficient to allow a thorough cleaning after shooting.





## 8.2 Magazine Disassembly

1. Depress the magazine follower.
2. Capture the magazine spring by inserting a small punch or pin through one of the cartridge witness holes in the magazine tube.
3. Lift and rotate the magazine follower until clear of the magazine tube.




4. Remove the magazine spring from the magazine tube.

## ⚠ WARNING

The magazine spring is compressed. Guard the magazine insert and magazine spring with your thumb to control the release of magazine spring tension. Uncontrolled release can cause injury. Wear eye protection.

## 8.3 Cleaning the Pistol

**⚠ WARNING**

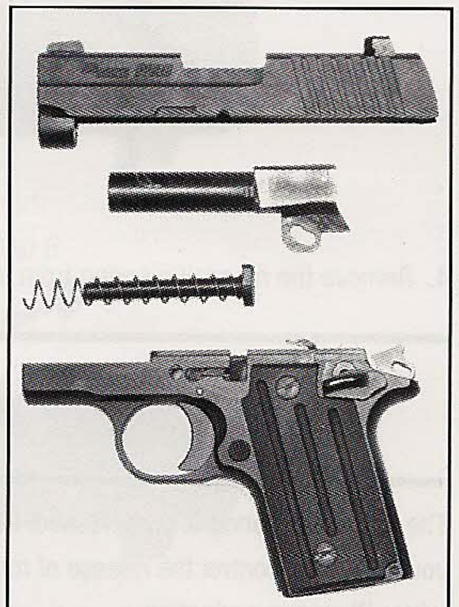
Never clean the barrel from the muzzle end; do not use a steel wire brush as it can damage the smooth surface of the barrel. Use a suitable cleaning rod and a brush of the correct caliber.

Solvents can be harmful to the surface finish of the pistol. Read and follow the manufacturer's warnings before using solvents or cleaners. Wear eye protection.

### Avoid over-lubrication of components.

1. Lubricate the cleaning brush with gun oil and insert it into the barrel via the chamber (opposite the muzzle end).
2. Wipe powder residues and oil from the barrel bore and chamber with cleaning patches.
3. Clean exterior surfaces of the barrel with a brush coated with gun oil.
4. Remove dirt from guides of the frame, inside and outside of slide, recoil spring guide and recoil spring with a brush or cleaning patch. Lightly lubricate same surfaces with a cloth impregnated with gun oil or gun grease.
5. Lightly oil bores of the barrel and chamber. Remove any excess lubricant.

*Note: TW-25B or a like lubricant designed for stainless steel is recommended for "All Stainless" models.*



**CAUTION: Avoid over lubrication of components.**

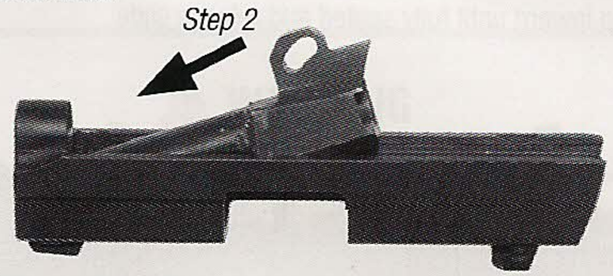




## 8.4 Pistol Assembly

1. Verify the pistol is clear of all foreign matter.
2. Insert the barrel into the slide.

*Step 2*

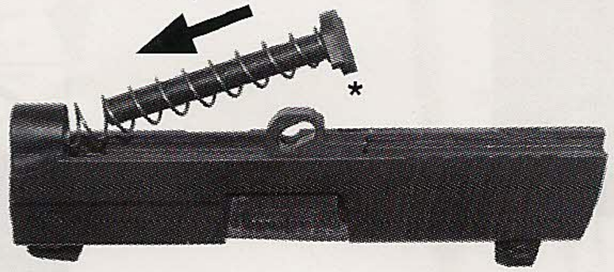


**⚠ WARNING**

The magazine spring is compressed. Guard the magazine insert and magazine spring with your thumb to control the release of magazine spring tension. Uncontrolled release can cause injury. Wear eye protection.

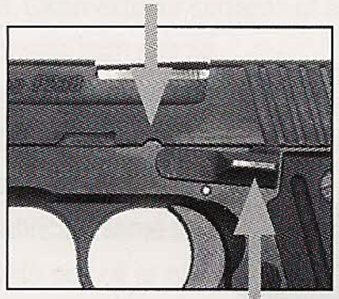
3. Insert recoil spring guide assembly into the slide.
   - note: notched portion of recoil guide towards barrel.*

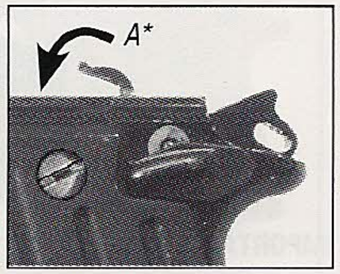
*Step 3*




**IMPORTANT:** Make sure the wide end of the spring is inserted into the slide first with the narrow end on the guide. Installing the spring backwards will result in damage to the spring box. To ensure optimal performance, the Recoil Spring should be replaced every 1,500 rounds.

4. Guide the slide assembly onto the frame rails from the front until the barrel lug is aligned with slide stop pin hole in frame and partially insert slide stop pin.
   - note: depress the ejector "A" to clear slide.*
5. Retract slide rearward until slide disassembly notch is aligned with slide stop tab.
6. Press slide stop inward until fully seated and release slide.







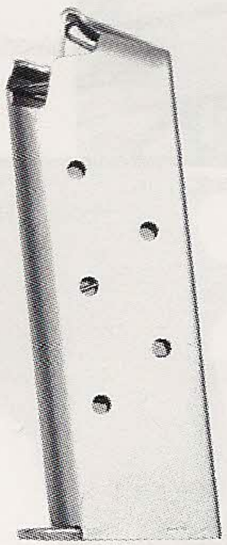

## 8.5 Magazine Assembly

1. Orient the magazine follower on the magazine spring and insert through the top of the magazine tube.

**⚠ WARNING**

The magazine spring is being compressed during assembly. Guard the magazine insert and magazine spring with your thumb to control magazine spring tension. Uncontrolled release can cause injury. Wear eye protection.

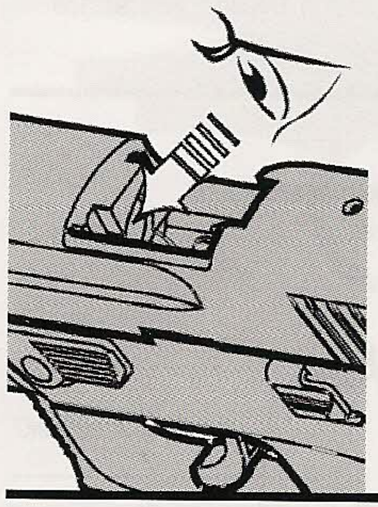
2. Rotate and depress the magazine follower until seated in the magazine tube.



## 8.6 Function Verification

The function check is performed on the assembled pistol to verify functionality. It should be performed after the completion of repairs and after each cleaning and assembly of the pistol.

### ⚠ WARNING – MAINTENANCE



Verify the magazine is removed – visually and physically confirm the pistol is unloaded before attempting disassembly or performing any maintenance steps. Failure to ensure the firearm is unloaded could result in unintentional discharge, causing injury or death.

**VERIFY THE FIREARM IS UNLOADED**





1. Ensure the magazine is removed and the pistol is unloaded (see section 6.0 "Unloading the Pistol")
2. Check recoil spring function & slide travel
   a. Retract slide fully and release
   b. Verify slide locks fully in the closed position
   c. Repeat the procedure

3. Check trigger mechanism and thumb safety
   a. Place thumb safety ON (safety UP)
   b. Depress trigger – hammer should NOT fall
   c. Place thumb safety OFF (safety down) – hammer should NOT fall
   d. Depress trigger – hammer should fall

4. Check slide stop
   a. Insert empty magazine
   b. Retract slide fully and release
   c. Verify slide is locked to the rear by the slide stop

d. Remove the magazine
e. Depress the slide stop
f. Verify slide is released and closes fully

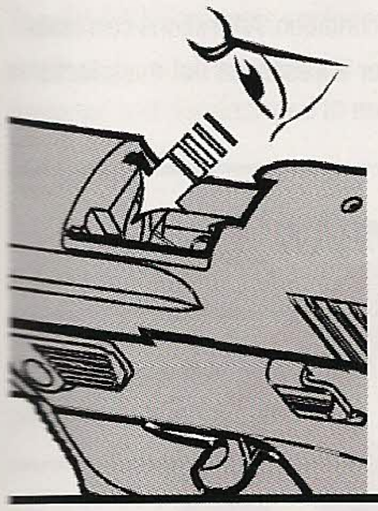
5. Inspect the magazine
   a. Check condition of magazine tube
   b. Check free movement of magazine follower and spring
   c. Insert magazine into pistol – verify smooth insertion and clean engagement.
   d. Depress magazine catch – ensure smooth release

6. Inspect the pistol exterior
   a. Inspect the general condition of the pistol
   b. Check the sights, frame, slide, slide stop for damage
   c. Verify the front & rear sights are secure





## ⚠ WARNING – INSPECTION



Never use a firearm or magazine that shows signs of damage or fails a function check. Verify the magazine is the correct model and caliber for the pistol. If the condition or function of the pistol or magazine is suspect, return the pistol or magazine to SIG SAUER for evaluation.

**VERIFY THE CONDITION AND FUNCTION**

## ⚠ WARNING – ALTERATIONS

This product was designed to function properly in its original condition. Alterations can make it unsafe. Do not alter any part or add or substitute any parts or accessories not manufactured by SIG SAUER for this pistol.

**DO NOT ALTER ANY GUN**





# 9.0 Sights

## 9.1 General Information

The SIG SAUER pistol is equipped with drift adjustable fixed sights which have proven their worth under severe conditions. The sights consist of a rear sight and a front sight blade, designed and dimensioned to ensure rapid target acquisition even when visibility is poor.

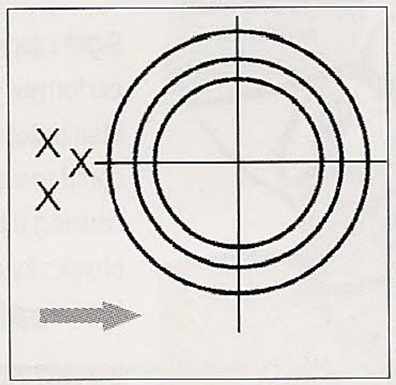
## ⚠ WARNING – SIGHT ADJUSTMENT

Sight corrections should only be performed by someone with the necessary knowledge – the pistol could become damaged.

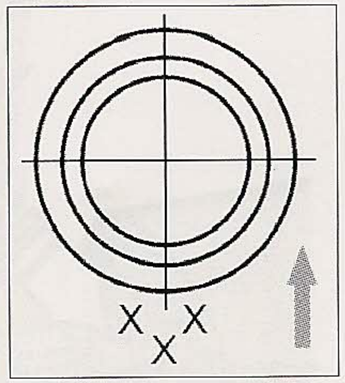
## 9.2 Windage (Left/Right) Adjustment

Change windage by moving the rear sight either to the left or right in its dovetail. When you do this, follow the rear sight rule: Move the rear sight in the direction you want the group to go. Moving the rear sight 0.020" in the dovetail changes the point of impact by approximately 3" at 25 yards.

*Note: SIG SAUER has a Sight Adjustment Tool available that makes it easier to adjust and change sights.*

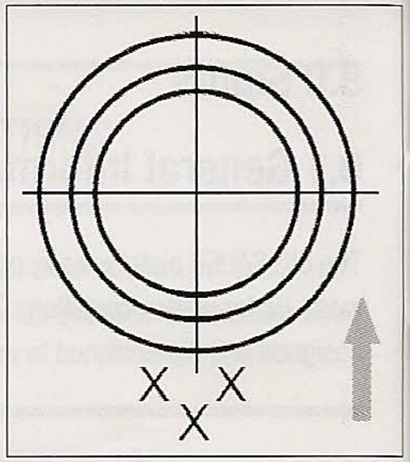


Impact left of point of aim



Impact low of point of aim

## 9.3 Elevation (Up/Down) Adjustment



Impact low of point of aim

There are different height combinations available for the front and rear sights. The sights are numbered according to their height. You can change elevation by changing either the rear or front sight. It's easier if you change the rear sight first.

There are six rear sight heights available. Each rear sight change will move the impact of the bullet approximately 2" at 25 yards.

There are five front sight heights available. Each front sight change will move the impact of the bullet approximately 1" at 25 yards.

When changing sights, remember this rule: NUMBERS UP, GROUPS UP; NUMBERS DOWN, GROUPS DOWN. This is true for both front & rear sights.

### ⚠ WARNING – SIGHT ADJUSTMENT

Sight corrections should ONLY be performed on an unloaded firearm. Manipulating the sights on a loaded firearm could result in unintentional discharge, causing injury or death. Visually and physically confirm the pistol is unloaded before making sight adjustments.

**DO NOT ADJUST THE SIGHTS ON A LOADED FIREARM**





## 10.0 Transportation and Storage

When transporting your firearm to and from shooting activities, keep it unloaded for your safety and for the safety of others. When storing your firearm, keep it separated from ammunition, under lock and key if possible, and out of the reach of children and other inexperienced or unauthorized persons.

### ⚠ WARNING – STORAGE

Never place or store any firearm in such a manner that it may be dislodged. Firearms should always be stored securely and unloaded, away from children and other unauthorized users. Use the locking device originally supplied with this firearm for storage. The use of a locking device or safety lock is only one aspect of responsible firearms storage. For increased safety, firearms should be stored unloaded and locked in a location that is both separate from their ammunition and inaccessible to children and any other unauthorized person.

**STORE SECURELY AND UNLOADED**

# 11.0 Service and Parts Policy

## 11.1 Parts Policy

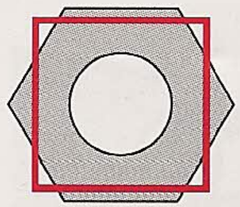
Our Service Department maintains a full complement of replacement parts. Even though most gunsmiths have the knowledge, training, and the ability to make necessary repairs to your firearm, the skill and workmanship of any particular gunsmith is totally beyond our control.

Should your firearm ever require service, we strongly recommend that you return it to SIG SAUER (see section 11.3 "Shipping Firearms for Repair"). A firearm is a precision instrument and some replacement parts will require individual fitting to ensure correct operation. A wrong part, improper fitting, or incorrect mechanical adjustment may result in an unsafe condition or dangerous malfunction, damage to the firearm, or cause possible serious injury to the shooter or others.

IF ANY PART IS ORDERED WITHOUT RETURNING THE FIREARM TO SIG SAUER, the customer bears full responsibility for ensuring that the part supplied is correct for their particular firearm and is properly installed and fitted by a qualified gunsmith.

SIG SAUER CANNOT BE RESPONSIBLE FOR THE FUNCTIONING OF ANY FIREARM IN WHICH REPLACEMENT PARTS ARE INSTALLED BY OTHERS.

### ⚠ WARNING – PARTS PURCHASERS



It is the purchaser's responsibility to be absolutely certain that any parts ordered from the factory are correctly fitted and installed. Firearms are complicated mechanisms and IMPROPER FITTING OF PARTS MAY RESULT IN A DANGEROUS MALFUNCTION, DAMAGE TO THE FIREARM, AND SERIOUS INJURY TO THE SHOOTER AND OTHER PERSONS. The purchaser and installer of parts must accept full responsibility for the correct adjustment and functioning of the firearm after such installation. **PARTS MUST FIT CORRECTLY**





## 11.2 Service Policy

If you have questions concerning the performance or servicing of your firearm, please write or call:

**SIG SAUER, Inc.**
**Attention: Customer Service**
**18 Industrial Drive Exeter, NH 03833**
**Phone: (603) 772-2302**
**Fax: (603) 772-9082**

**IF YOU DO NOT UNDERSTAND THE INSTRUCTIONS FOR OPERATING YOUR PISTOL, IT IS YOUR RESPONSIBILITY TO CALL OUR CUSTOMER SERVICE DEPARTMENT AT (603) 772-2302 BEFORE USING YOUR FIREARM.**

## 11.3 Shipping Firearms for Repair

In the event you need to return your firearm to the SIG SAUER Service Department, here's what to do:

1. First contact Customer Service at (603) 772-2302 for an RMA number, which will allow SIG SAUER to track the status of your return from its receipt at SIG SAUER through its return to you. Please do not send your firearm until you obtain an RMA number.

2. Make sure that the chamber and magazine(s) are unloaded and that no ammunition is included with your returned firearm.

3. Package the firearm securely to prevent damage. Enclose a letter that includes your name, street address, daytime phone number, model and serial number, and a detailed description of the problem you have experienced or the work you want performed. With the exception of extra magazines, do not include any other accessories such as scopes or mounts.

4. Generally, an individual may ship firearms to the manufacturer for repair or service. Some states and localities, however, prohibit this. If you live in such an area, the firearms must be shipped by and returned to a federally licensed firearms dealer.

5. Federal law prohibits persons who do not possess a Federal Firearms License from shipping a firearm via the U.S. Postal Service. (Note: any shipment of firearms outside U.S. borders is subject to the export laws of the United States and to the valid laws of the specific country, which you must strictly follow; prior to exporting any firearm you should seek legal counsel.)

6. SIG SAUER is not responsible for any firearm until it is received, nor for damage incurred during shipment.

7. Ship your firearms insured and prepaid (we do not accept collect shipments) to:

**SIG SAUER, Inc.**
**Attention: Service Department**
**18 Industrial Drive Exeter, NH 03833**

Don't forget to write your RMA number on the package.

**A copy of this instruction manual should always accompany this pistol and be transferred with it upon change of ownership.**





## 11.4 Ordering Parts

In the event you want to order parts for your firearm, contact Customer Service at (603) 772-2302.

Have available the serial number of your firearm and the part diagram number for the part(s) you wish to order. A parts list and diagram of the pistol is provided in section 13.0.

Please refer to the Service and Parts Policy.

### ⚠ WARNING – SHIPPING

Before shipping any firearm, be absolutely certain that the firearm and its magazines are unloaded.

DO NOT ship ammunition with a firearm. Failure to follow this warning could result in unintentional discharge, causing injury or death.

**VERIFY THE FIREARM IS UNLOADED**

## 13.0 Specifications

| | Nitron | Two-Tone | Stainless |
|---|---|---|---|
| Caliber | .380ACP (9mm short) | | |
| Magazine Capacity | 6 | | |
| Trigger Pull | SAO: 7.5 - 8.5 lbs | | |
| Overall Length | 5.5” | | |
| Overall Height | 3.9” | | |
| Overall Width | 1.1” | | |
| Barrel Length | 2.7” | | |
| Sight Radius | 3.8” | | |
| Sights[1] | Contrast or SIGLITE® Night Sights | | |
| Weight w/ Magazine | 15.2 oz | 15.2 oz | 20.1 oz |
| Frame Material | Aluminum | Aluminum | Stainless |
| Frame Finish | Hard coat anodize | Hard coat anodize | Natural Stainless |
| Slide Material | Stainless Steel | | |
| Slide Finish[2] | Nitron® | Natural Stainless | Natural Stainless |
| Grips[3] | Black Polymer | Gray Polymer | G10 |

[1] TRUGLO® TFO Front Sight - Equinox®

[2] Nitron w/ ground slide flats & flat top - Equinox

[3] Optional: Custom Wood, Aluminum, G10

Specifications subject to change without notice.





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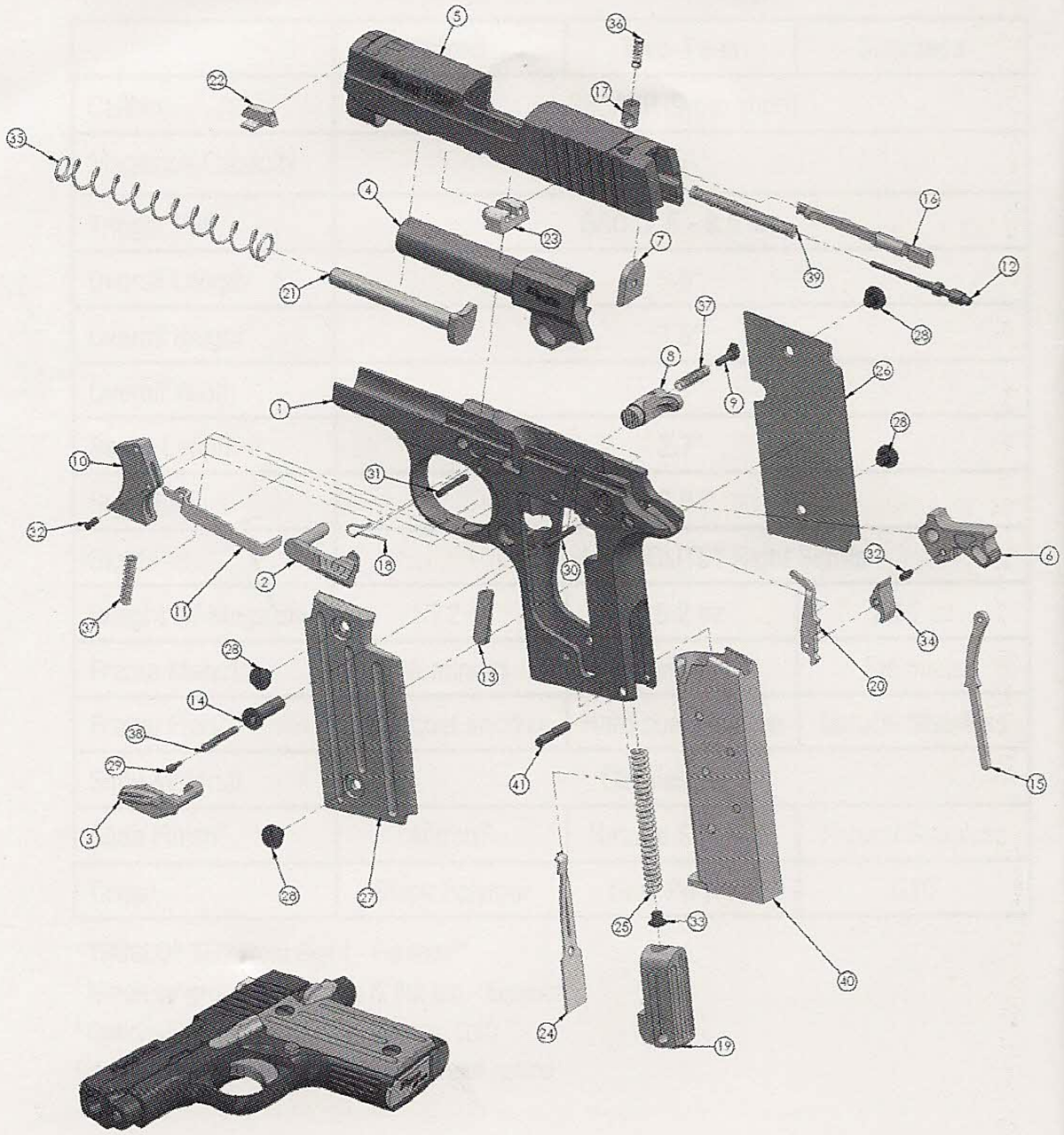
## 13.1 Parts Diagram





## 13.2 Parts List

| Item | Description | Item | Description |
|---|---|---|---|
| 1 | Frame | 22 | Front Sight |
| 2 | Slide Stop | 23 | Rear Sight |
| 3 | Thumb Safety | 24 | Sear Spring |
| 4 | Barrel | 25 | Mainspring |
| 5 | Slide | 26 | Right Grip Plate |
| 6 | Hammer | 27 | Left Grip Plate |
| 7 | Firing Pin Stop | 28 | Grip Plate Screw |
| 8 | Magazine Catch | 29 | Safety Detent Plunger |
| 9 | Magazine Catch Lock | 30 | Sear Pin |
| 10 | Trigger Pad | 31 | Trigger Pin |
| 11 | Trigger Bar | 32 | Trigger Bar Pin |
| 12 | Firing Pin | 33 | Mainspring Housing Pin Lock |
| 13 | Disconnector | 34 | Sear |
| 14 | Hammer Pin | 35 | Recoil Spring |
| 15 | Hammer Strut | 36 | Firing Pin Block Spring |
| 16 | Extractor | 37 | Magazine Catch / |
| 17 | Firing Pin Block | | Trigger Bar Spring |
| 18 | Slide Stop Pin | 38 | Safety Plunger Spring |
| 19 | Mainspring Housing | 39 | Firing Pin Spring |
| 20 | Ejector | 40 | Magazine |
| 21 | Recoil Spring Guide | 41 | Mainspring Housing Pin |

## THE BASIC RULES OF SAFE FIREARMS HANDLING

1. ALWAYS treat every gun as if it were loaded.
2. ALWAYS be sure the barrel is clear of any obstruction.
3. ALWAYS be sure of your backstop, what lies beyond, and the safety of bystanders before you shoot.
4. ALWAYS use clean, dry, original factory-made ammunition of the proper type and caliber for your gun.
5. ALWAYS wear ear protection and safety glasses when shooting.
6. ALWAYS carry your gun so that you can control the direction of the muzzle if you fall or stumble.
7. NEVER shoot at a flat surface or water.
8. DO NOT leave an unattended gun loaded. Guns and ammunition should be stored separately, locked if possible, beyond the reach of children, careless adults, and unauthorized users.
9. NEVER allow your firearm to be used by anyone who has not read and understood this operator's manual.
10. DO NOT point any gun, loaded or unloaded, at any undesired target.
11. NEVER fire your rifle near an animal unless it is trained to accept the noise: an animal's startled reaction could injure it or cause an accident.
12. NEVER drink alcoholic beverages or take drugs before or during shooting, as your vision and judgment could be seriously impaired, making your gun handling unsafe.





## SIG SAUER® Limited Lifetime Firearms Warranty

SIG SAUER® warrants that the enclosed firearm was originally manufactured free of defects in material, workmanship and mechanical function. For the lifetime of the original purchaser, SIG SAUER agrees to correct any defect in the firearm for the original purchaser by repair, adjustment or replacement, at SIG SAUER's option, with the same or comparable quality components (or by replacing the firearms at SIG SAUER's option); provided, however, that the firearm is returned unloaded and freight prepaid to:

**SIG SAUER**
**18 Industrial Drive**
**Exeter, NH 03833**

This limited warranty is null and void if the firearm has been misused, damaged (by accident or otherwise), fired with handloaded, reloaded or improper ammunition, fired with an obstruction in the barrel, damaged through failure to provide reasonable and necessary maintenance as described in the manual accompanying the firearm, or if unauthorized repair or any alteration, including of a cosmetic nature, has been performed on the firearm. This limited warranty does not apply to normal wear and tear of any parts. Subject to the foregoing, this limited warranty confers the right to have the covered firearm or its parts repaired, adjusted or replaced exclusively upon the original purchaser, which right is not transferable to any other person. No implied warranties of any kind are made herein and this warranty does not apply to any accessory items attached or appurtenant to the firearm. In no event shall SIG SAUER be liable for any incidental or consequential damages arising from or in connection with this limited warranty.